Accept	Work Order ID 69634 hursday, May 12,,2011 3:45:45 F	PM	,			Ť	ASA	Pi	1	Page 1
Start Date: 5/13/2011 Start Qty: 4.00 Cust Item ID: Customer:	tevision ID:		A	Accept				-		
Approvals: Process Plan: 904 Date: SPC (Y/N): Date: Stop Work Center ID Description Set Up/ Run Hours Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description Run Hours O.00 Bandsaw Memo Cut blank: 2.00" x 2.25" x 7.370" long O.00 HAAS CNC VERTICAL MACHINING #1 HAAS CNC vertical machine #1 As SCNC vertical machine #1 Comparison Date: SPC (Y/N): Date: Stop Work Code On the plan Accept Reject	tart Date: 5/13/2011 Sta Required Date: 5/20/2011 Rec	- •				<u>):</u>			#	
Nork Center ID Description Run Hours Code Qty Qty Number Stamp Rev B OO BAND SAW Amdsaw Memo Cut blank: 2.00" x 2.25" x 7.370" long OO HAAS CNC VERTICAL MACHINING #1 I-Machine D3371-3 as per Folio FA486 and Dwg D3371 2-Deburr 3-Finish 8-32 thread by hand Identify as D3371-3 Identify as D3371-3 OO QC2- Inspect parts off machine FAI/FAIB OO QC2- Inspect parts off machine FAI/FAIB OO DAA OO Amber Stamp OO Am	00-		•		Ψ.	200000000000000000000000000000000000000	· 			
Draw Nbr					Tool ID		•			
BAND SAW Bandsaw Memo Cut blank: 2.00" x 2.25" x 7.370" long HAAS CNC VERTICAL MACHINING #1 HAAS 1 IAAS 1 IAAS CNC vertical machine #1 I-Machine D3371-3 as per Folio FA486 and Dwg D3371 2-Deburr 3-Finish 8-32 thread by hand Identify as D3371-3 QC2- Inspect parts off machine FAI/FAIB O.00 BAND SAW U 55/8 U 65/8 LA 11/05/18 LA 11/05/18		Nbr		¥					1	
HAAS CNC VERTICAL MACHINING #1 Memo 1-Machine D3371-3 as per Folio FA486 and Dwg D3371 2-Deburr 3-Finish 8-32 thread by hand Identify as D3371-3 QC2- Inspect parts off machine FAI/FAIB 0.00 A 11 05 18	Bandsaw	Memo	x 7.370" long	0.00 mg	21/05/18		tj	- 8		
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MINIMINI	AAS CNC vertical machine #1	1-Machine D3371-3 as pe 2-Deburr 3-Finish 8-32 thread by h		€ C	מון כיין ווי א					×
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W/O:		Liu		ORK ORDER CH	ANGES					
DATE	STEP	PF	ROCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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_		_		tegory: Maching			No DQ	A: 4		10.27
(D)	R	esolution:	Disposit	ion: State	DMANCE	: N/C CI	osed:	<u> 4</u>	Date: _	H/02/24
NCR: 3	69634		WORK OR	DER NON-CONFO		= (NCH	30.5	67	T	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Descrip Chief Eng	Section B	Sign & Date		cation ion C	Approval Chief Eng	Approval QC Inspecto
wisty	H IW	Dim. 1.330 ± 005 is neason. 1.304/1.300. (.025/03004). R.C. Part lifte During man	,	-> SCRAP + REG B: !12764	PLACE.	11/05/1	7 11/09		105.19 05104Z	Sulvelis
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NOTE: D	ate & initi	al all entries	L	<u> </u>						

* H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

140

QC

HandFinish

Quality Control

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

and 11/05/19

Memo

Memo

_0.00

145

Powdercoat

Powder Coating

4102301

Fire Red(Ref:4.3.5.10) per QSI005 4.3

0.00

Memo

0.00

cover inside holes prior painting

Page 2

4x & m/ 11/05/20





Reject Insp.

Stamp

_4____

W/O:			VV	ORK ORDER CH	ANGES	İ				
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date C	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cat	egory:	1	NCR: Yes	No DQA:		Date:	
	R	esolution:	Dispositi	on:	(A: N/C Cld	osed:		_ Date: _	
NCR:		•	WORK ORI	DER NON-CONFO	RMAN	CE (NCR)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Action Descrip	Section E	Sign &	Verificat Section		Approval Chief Eng	Approval QC inspector
			Chief Eng	Chief Eng		Date			.,.	
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Work Order ID 69634

Thursday, May 12, 2011 3:45:46 PM



Page 3

Item ID:

D3371-3

Accept

Setup Start



Revision ID:

Item Name:

Pedal Lock Cover

Start Date: 5/13/2011 Required Date: 5/20/2011

Start Oty: 4.00

Reg'd Otv: 4.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date: Tooling:

SPC (Y/N):

Date: Date:

Run

Start

Stop



Stop

Sequence ID/ Work Center ID

150

OC

Quality Control

Operation Description

OC3- Inspect Part Finish

Memo

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

160

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

Sb 165/24

170

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W/O:			V	ORK ORDER CH	ANGES					
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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								<u> </u>	**************************************	
		•								
Part No	:	PAR #:	Fault Ca	tegory:	NCI	R: Yes N	lo DQ	4:	Date:	<u> </u>
	R	esolution:	Disposit	ion:	QA	: N/C Clos	sed:		Date:	
NCR:			WORK OR	DER NON-CONFO	RMANCE	(NCR)				
DATE	STEP	Description of NC	4	Corrective Action	Section B	Sign &	Verific		Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Descrip Chief Eng	riou	Date	Secti	on C	Chief Eng	QC Inspector
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Picklist Print

Thursday, May 12, 2011 3:45:39 PM

Work Order ID: 69634

Parent Item: D3371-3

Parent Item Name: Pedal Lock Cover



Start Date: 5/13/2011

Required Date: 5/20/2011

Page 1

Start Oty: 4.00

Required Otv: 4.00

Comments:

IPP A□05.01.18□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X02.25		Purchased	No		100	f	0.0000	0.625	2.631579)		



6061-T6 Bar 2.00 x 2.25

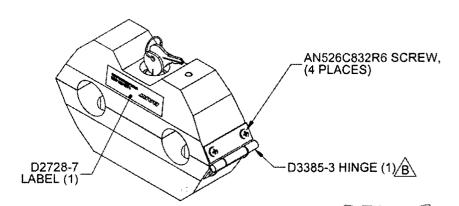
6061-76 2.00"×3.500" M112764 ×4 = 2.6316

W/O:			V	ORK ORDER CH	ANGES					
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Ca	tegory:	N	CR: Yes	No DQ	\:	Date:	
		esolution:								
NCR:		\	WORK OR	DER NON-CONFO	RMANC	E (NCR	1)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Action Descrip	Section B tion	Sign 8	Verific Section		Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng		Date		<u></u>		

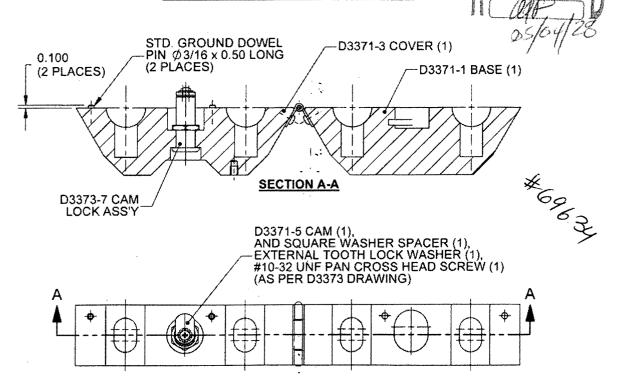
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DESIGN 3 DRAWN BY			BY	DART AEROSP HAWKESBURY, ONTA		
CHECK	ED.	APPRO	VES.	DRAWING NO.	REV. B	
*	7	/4/1		D3371	SHEET 1 OF 4	
DATE	DATE		•	TITLE	SCALE	
05.03.22			PEDAL LOCK	1:3		
A 04.12.06			NEW ISSUE			
B 05.03.22			D3385-3 WAS D3385-1			



PEDAL LOCK SHOWN LOCKED WITH KEY



D3371-051 PEDAL LOCK ASSEMBLY

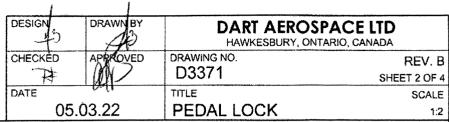
NOTES:

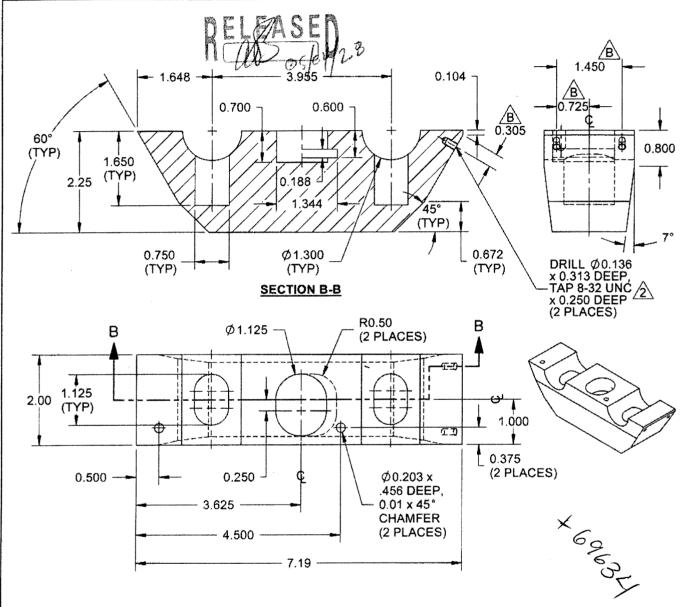
1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 2) ALL DIMENSIONS ARE IN INCHES

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W/O:				W	ORK ORDER CHANGE	ES				
DATE	STEP	PRO	CEDUR	E CH	ANGE	Ву	Da	ate Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fau	lt Cat	egory:	NCR: Yes	s No	DQA:	Date: _	
	R	esolution:	_ Disp	ositi	on:	QA: N/C	Close	d:	Date: _	
NCR:		W	ORK	ORI	DER NON-CONFORMA	NCE (NC	R)			
DATE	OTED	Description of NC			Corrective Action Section		,	Verification	Approval	Approval
DATE	STEP	Section A	Init Chief		Action Description Chief Eng	Sign Dat	1 & .	Section C	Chief Eng	QC Inspector
		,								į
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D3371-1 BASE

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B) 2) COVER INSIDE HOLES PRIOR PAINTING
- 2) COVER INSIDE HOLES PRIOR PAINTING
 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES
 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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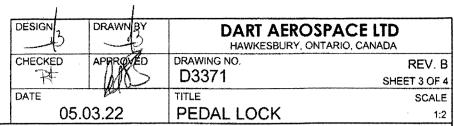
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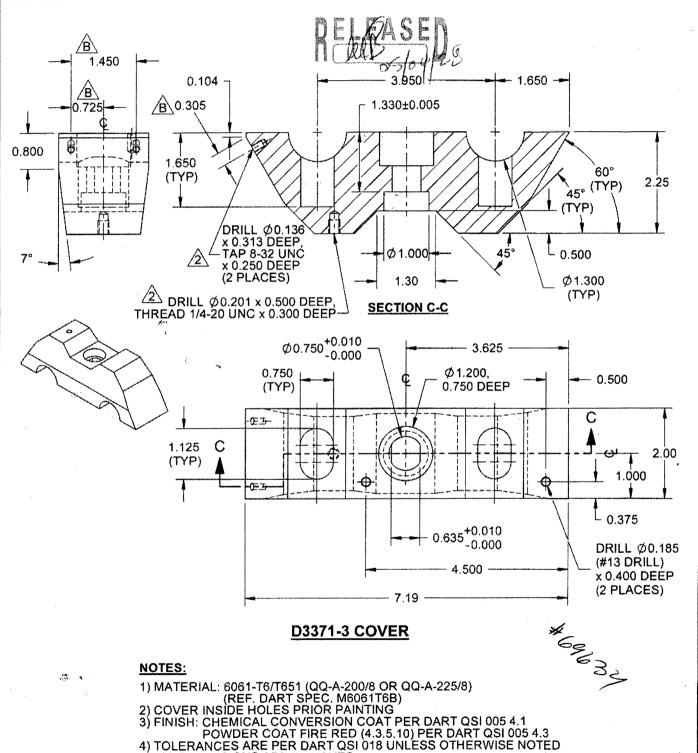
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w/o:		***		WORK	ORDER CHANGE	ES			·		
DATE	STEP	PRO	CEDURE	E CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault	Category	:	NCF	R: Yes	No DQA	۸:	Date: _	
	R	esolution:	Disp	osition: _		QA:	N/C CI	osed:		Date: _	
NCR:			WORK (ORDER	NON-CONFORMA	NCE	(NCF	R)			
		Description of NC		Cor	rective Action Section	n B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initia Chief	1	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
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	1										

NOTE: Date & initial all entries

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5) ALL DIMENSIONS ARE IN INCHES 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 4

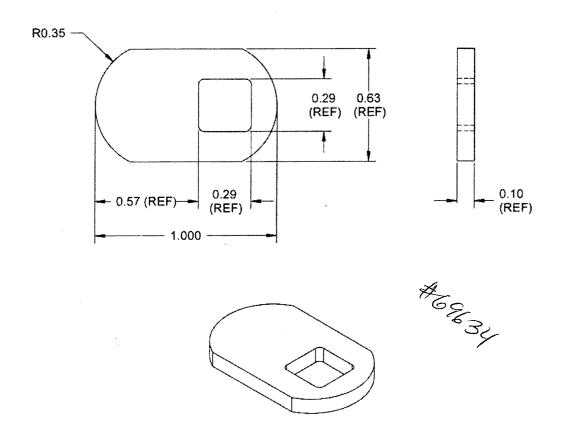
W/O:			V	VORK ORDER CHAN	NGES			
DATE	STEP	PRO	OCEDURE CH	IANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		ž.						
Part No	:	PAR #:	Fault Ca	tegory:	NCR: Yes 1	No DQA :	Date: _	
	Re	esolution:	Disposit	ion:	QA: N/C Clo	sed:	Date: _	
NCR:			WORK OR	DER NON-CONFOR	MANCE (NCR)			
DATE	STEP	Description of NC	12451		Section B	Verification	Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	on Sign & Date	Section C	Chief Eng	QC Inspector
		, , , , , , , , , , , , , , , , , , , ,						



DESIGN 力	DRAWNBY	DART AEROS HAWKESBURY, ON	
CHECKED	APPROVED	DRAWING NO.	REV. B
H	11000	D3371	SHEET 4 OF 4
DATE		TITLE	SCALE
05	.03.22	PEDAL LOCK	2:1



SPECIFICATION CONTROL DRAWING



D3371-5 CAM

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 3) ALL DIMENSIONS ARE IN INCHES
 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Dail Aciusuale Liu	Dart	Aeros	pace	Ltd
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W/O:				V	ORK ORDER CHANGES		•			
DATE	STEP	PRO	CEDUR	E CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Faul	t Ca	tegory: NC	R: Yes	No DQ	\ :	Date:	
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DATE	STEP	Description of NC			Corrective Action Section B	0: 0	Verific	ation	Approval	Approval
DAIL	SILF	Section A	Initi Chief		Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	69634
Description: Pedal Lock Cover	Part Number:	D3371-3
Inspection Dwg: D3371 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing		Actual	Accept Rejec		Method of	Comments
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
1.450	+/-0.005	1,450	7		Veca	6A-01
7°	+/-0.5°	70	1		Angle Meter	CNC ~08
					J	
0.104	+/-0.010	0.105		Fe _s	Vern	69-01
0.305	+/-0.010	0.312	/		11	1)
1.650	+/-0.010	1. 648	~		11	1.
1.30	+/-0.030	1,300	✓		11	()
Ø1.000	+/-0.010	91.003	/		#1	1)
45°	+/-0.5°	45°	~		Angle Meter	CNCOS
Ø1.300	+/-0.010	\$ 1.360	~		Vera	GA-01
0.500	+/-0.010	0.498	~		11	1/
60°	+/-0.5°	600	~		Angle Meter	CNC-08
2.25	+/-0.030	2.251	~		Veco	GA-0)
1.650	+/-0.010	1.649	/		D-6	6A-08
3.950	+/-0.010	3.950	~		۷۷۱	6A-01
1.330	+/-0.005	1.330	~		H-6	31006
7.19	+/-0.030	7.188	~		Vera	CNC-07
4.500	+/-0.010	4.498	~		Veca	GA-01
0.635	+0.010/-0.000	0.635	✓		t)	((
1.125	+/-0.010	1.125	1		11	. 1
0.750	+/-0.010	0.751			4	4
Ø0.750	+0.010/-0.000	Ø 0,758	~		4	4
3.625	+/-0.010	3.622				11
Ø1.200	+/-0.010	\$ 1.201	~		4	9
0.750 deep	+/-0.010	0.751 deep	1		ł1	()
0.500	+/-0.010	0.501	~	_	/1	11
2.00	+/-0.030	1.996	✓		11	
1.000	+/-0.010	0.997	~		11	.1
0.375	+/-0.010	0,373	~		/(
Ø0.185	+0.005/-0.000	\$ 0.180	✓		11	6 /
0.400 deep	+/-0.010	0.401 deep	✓		11	11

Measured by:	J.A	Audited by:	anl	Prototype Approv	al: N/A
Date:	11/05/18	Date:	11/05/19	. Da	te: N/A

A: 05.04.26 New Issue KJ/JLM K	Rev	Date	Change	Revised by	Approved
B 05 05 25 Revised dimensions KJ/JLM XV (///	A·	05.04.26	New Issue	KJ/JLM 1.A	
B 00:00:20 Trevious dimensions	В	05.05.25	Revised dimensions	KJ/JLM 🖟	

W/O:	-			WORK ORDE	R CHANGES					Tage .
DATE	STEP	**	PROCEDUR	E CHANGE	-	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
										÷
									es , . ·	· ·

Part No: _		PAR #: Fau	t Category:	NCR: Yes No DQA:	Date:
-é	Resolution:	Dis	osition:	QA: N/C Closed:	Date:

		Description of NC	T ,	Corrective Action Section B	· · · · · · · · · · · · · · · · · · ·	Verification		Approval
DATE STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto		
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	-						**	*
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